

62

20081B

T AEROSPACE LTD		Work Order:	20081
Description: Bearpaw Kit (19" x 24")		Part Number:	K10008
Dwg: D2432 Rev. F3		Qty:	20 Kits
Ref: K10008 Rev. E		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required	HJ	03.12.16	10
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 (Bag Bluefiles separately)	HJ	03.12.19	10
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 20.00" x 24.00" x 1.00" thick Material: Black UHMW 1" (MUHMWB10)	RJ	04.01.08	20
4	MV	Inspect material for defects or damage prior to machining	OP	04/02/2016	X6
5	MV	Machine as per Folio D2432 and Dwg D2432	OP	04/02/2016	X6
6	QC2	Inspect parts as they come off the CNC machine	EP	04/02/2016	X6
7	MV	Deburr	EP	04/02/2016	X6
8	QC8 & 5	Second inspection	EP	04.02.02	X6
9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3)			
		Qty Part Number Description Batch			
		6 D2182B050 Rubber Cushion B19540			
		12 D2274 Radius Block B19540 B19518			X6
		2 D2432F 24" Bearpaw B20081			
		6 D2438 Clamp B200805 B19615			
		12 D2529 Washer B20090			
		6 D2732-050 Rubber Cushion B18806			
		12 AN4-15A Bolt m13437			
		12 AN4-17A Bolt m12692			
		24 AN960JD416 Washer m13719			
		12 MS21042L4 Nut (or -4) m13276			
		1 Paperwork package from Step 2			
10	QC4	Inspect Kit for 100% Completeness on the W/O	OP	04.01.26	X6
11	PK	Identify and pack for shipping as per PPP K10008	OP	04.01.27	X6
12	AC	Cost / part 204.52	SGC	04.02.04	X6
13	DC	Close W/O 239.79 Inspect Level 21	HJ	04.02.05	X6

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	#

1900-1905

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector
		REFERENCE ONLY							

NCR 20081B		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC Section A		Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
04.02.02	5	1 bearpaw scrap, hole misaligned - operator error.		Initial	S not destroy put remaining bearpaw 3 stores	R 04.02.02	R 04.02.02	R/A	R/B 04.02.02
		Systech wanted to shir shirt so he said pants were no good			D2432F				

PAR#: _____ Fault: _____ Category: _____ DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
04.02.02	5	I bearpaw scrap, hole misaligned - operator error.	Initial	Scrap destroy	Sign & Date 04.02.02	Verification 04.02.02	Approval Design Mgr R/A	Approval QC Inspector R	
		Systair wanted to stir stir so he said parts were no good.							

PAR#: N/A Fault Category: manuf-CNC DQA: RDate: 04.02.03NOTE: Date & initial all entries
H:Admin-QA\ISO\forms\w\oncB.docQA: N/C Closed: NDate: 04.02.03

DART AEROSPACE LTD		Work Order:	20081B
Description: Bearpaw Kit (19" x 24")		Part Number:	K10008
Dwg: D2432 Rev. F3		Qty:	3 Kits
Ref: K10008 Rev. E			Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																	
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Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
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Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial						

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	20081B
Description: Bearpaw	Part Number:	D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/o K10008/0206-559-015	KJ/RF

RELEASED

24.2.15

Job Costing Report

Dart Aerospace Ltd.
HawkesburyFeb 02, 2004
01:43 pm

Work Order No : 0020081B
 Project Name : *K10008
 Project For : WK406
 Work Order Type : Main
 Main WO Number :
 House Part Number : *K10008
 Description : Bearpaw kit 19" x 24"
 Manufactured : Yes
 Amount Req'd : 3
 Amount Done : 0
 Start Date : 02-02-04
 Est Finish Date : 02-04-04
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Margin : 0.000%
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	0.00	0.00	0.00		
<hr/>					
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00

DART AEROSPACE LTD		Work Order: 20081B
Description: <i>BEAL PAW</i>		Part Number: 02432
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $0.063 \times 45^\circ$	± 0.010	$0.063 \times 45^\circ$	✓			
B 5.500	± 0.010	5.500	✓			
C 0.200	± 0.010	0.194	✓			
D $0.25 \times 45^\circ$	± 0.030	$0.25 \times 45^\circ$	✓			
E R 0.250	± 0.010	0.250	✓			
F 0.250	± 0.010	0.249	✓			
G 0.625	"	0.624	✓			
H 0.375	"	0.385	✓			
I 0.950	"	0.962 0.962	✓			
J 19.000	"	19.000 19.000	✓		TAPE MEASURE	
K 5.14	± 0.030	5.139	✓			
L 3.28	"	3.270	✓			
M 0.260	± 0.010	0.260	✓			
N $\phi 0.93$	± 0.030	0.925	✓			
O 0.30	"	0.327	✓			
P 23.750	± 0.010	23.750	✓			
Q 6.750	"	6.753	✓			
R 4.250	"	4.250	✓			
S 2.000	"	1.993	✓			
T						
U						
V 0.375	± 0.010	0.365	✓			

Measured by: <i>EP</i>
Date: 04/02/01

Audited by: <i>EC</i>
Date: 04/02/01

Prototype Approval: <i>N/A</i>
Date: <i>N/A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

